

Date: Thursday, 7/20/2006 1:05:49 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
 Job Number : 27994
 Estimate Number : 10533
 P.O. Number : NIA Part Number : D2573
 This Issue : 7/20/2006 S.O. No. : NIA Drawing Number : D2573 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : 7/20/2006 Type : MACHINED PARTS Drawing Revision : E
 Previous Run : 27889 Material : NIA
 Due Date : 8/5/2006 Qty: 16 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature] 06.07.21
 Comment : Est: 1 As Per RevE 06-01-27 JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6101007	7075-T7351 8.25X7.75X2.5
-----	----------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: B25354

J.G

06/09/01

16

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 27994 Double check by: SD

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

ml/5/J.G

06/09/06

16

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

ml

06/09/17

16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml/5/J.G

06/09/06

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/10/03

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:05:49 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 27994

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 06/09/22 16

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAB 06/09/24 16

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

06/10/02 x 16

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/10/02 (16)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51351

06/10/02 (16)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/10/03

Job Completion



06-10-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 27994
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.747	1.746	1.748	1.750		
C	3.495	3.505		3.496	3.496	3.500	3.500		
D	1.745	1.755		1.747	1.746	1.748	1.750		
E	7.990	8.010		8.001	8.005	8.006	8.004		
F	0.490	0.510		0.500	0.500	0.497	0.501		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.510	0.501	0.500	0.503		
J	1.174	1.184		1.177	1.176	1.177	1.179		
K	0.558	0.578		0.569	0.564	0.564	0.570		
L	1.174	1.184		1.177	1.176	1.177	1.179		
M	1.365	1.375		1.368	1.365	1.370	1.372		
N	2.495	2.505		2.500	2.497	2.495	2.497		
O	4.119	4.129		4.119	4.126	4.120	4.124		
P	0.115	0.135		0.119	0.123	0.125	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.241	0.242	0.243	0.244		
S	0.115	0.135		0.124	0.120	0.123	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.228	3.230	3.230	3.230		
V	0.230	0.250		0.239	0.230	0.230	0.234		
W	0.115	0.135		0.115	0.117	0.121	0.120		
X	0.308	0.313		0.310	0.311	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.766	0.760		
Z	0.352	0.372		0.369	0.368	0.369	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.635	0.630	0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.240	0.240	0.240	0.240		
AE	1.500	1.520		1.502	1.512	1.512	1.514		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.248	0.240	0.244		
AI	2.000	2.020		2.002	2.003	2.002	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: J.G. / *[Signature]*
Date: 06/09/06 / 06/09/12

Audited by: MS
Date: 06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 27994
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.747	1.748	1.748	1.747		
C	3.495	3.505		3.499	3.500	3.495	3.498		
D	1.745	1.755		1.747	1.748	1.748	1.747		
E	7.990	8.010		8.004	8.005	8.004	8.004		
F	0.490	0.510		0.503	0.498	0.500	0.501		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.501	0.498	0.501	0.501		
J	1.174	1.184		1.178	1.175	1.176	1.176		
K	0.558	0.578		0.568	0.566	0.563	0.562		
L	1.174	1.184		1.178	1.175	1.176	1.176		
M	1.365	1.375		1.368	1.367	1.368	1.367		
N	2.495	2.505		2.500	2.500	2.495	2.496		
O	4.119	4.129		4.122	4.123	4.120	4.123		
P	0.115	0.135		0.123	0.125	0.125	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.254	0.254	0.254		
S	0.115	0.135		0.118	0.120	0.120	0.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.230	0.230	0.240	0.240		
W	0.115	0.135		0.122	0.123	0.123	0.118		
X	0.308	0.313		0.309	0.310	0.308	0.310		
Y	0.760	0.765		0.760	0.766	0.760	0.766		
Z	0.352	0.372		0.369	0.369	0.369	0.369		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.626	0.629	0.631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.243	0.249	0.244		
AE	1.500	1.520		1.512	1.510	1.512	1.513		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.249	0.250	0.251		
AI	2.000	2.020		2.002	2.000	2.002	2.002		
AJ	0.023	0.043		0.033	0.038	0.033	0.033		
Accept/Reject									

Measured by: <i>SP 19m2</i>
Date: 06/09/17

Audited by: <i>MB</i>
Date: 06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 27994
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4 12		
A	0.438	0.443	DT8682	—	—	—	—		
B	1.745	1.755		1.749	1.746	1.750	1.745		
C	3.495	3.505		3.501	3.500	3.498	3.499		
D	1.745	1.755		1.745	1.746	1.750	1.745		
E	7.990	8.010		8.006	8.004	8.005	8.004		
F	0.490	0.510		0.499	0.498	0.498	0.493		
G	0.257	0.262	DT8683	—	—	—	—		
H	0.375	0.380	DT8684	—	—	—	—		
I	0.490	0.510		0.499	0.499	0.499	0.501		
J	1.174	1.184		1.175	1.175	1.175	1.175		
K	0.558	0.578		0.564	0.563	0.565	0.564		
L	1.174	1.184		1.175	1.175	1.175	1.175		
M	1.365	1.375		1.368	1.369	1.367	1.367		
N	2.495	2.505		2.496	2.495	2.497	2.496		
O	4.119	4.129		4.124	4.122	4.121	4.119		
P	0.115	0.135		0.125	0.123	0.124	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.253	0.254	0.253		
S	0.115	0.135		0.118	0.120	0.121	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.241	0.238	0.237	0.239		
W	0.115	0.135		0.122	0.121	0.123	0.119		
X	0.308	0.313		0.316	0.308	0.310	0.316		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.365	0.364	0.368	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.632	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.244	0.246	0.249		
AE	1.500	1.520		1.510	1.511	1.513	1.511		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.251	0.246	0.244		
AI	2.000	2.020		2.000	2.001	2.003	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: En 19m/
Date: 06/07/17

Audited by: Mrs 06/09/22
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27994
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

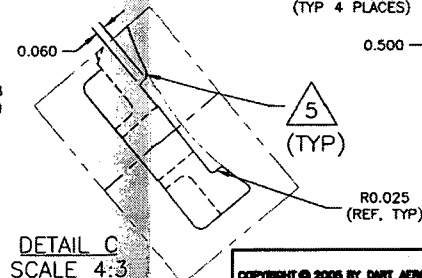
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4 /16		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.749	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.006	8.005	8.005		
F	0.490	0.510		0.501	0.505	0.501	0.502		
G	0.257	0.262	DT8683						
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.504	0.502	0.502	0.502		
J	1.174	1.184		1.186	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.567	0.568		
L	1.174	1.184		1.180	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.376	1.370	1.370		
N	2.495	2.505		2.500	2.506	2.500	2.500		
O	4.119	4.129		4.122	4.121	4.121	4.122		
P	0.115	0.135		0.123	0.123	0.122	0.122		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.254	0.255	0.253	0.254		
S	0.115	0.135		0.120	0.121	0.120	0.117		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.243	0.245	0.240	0.240		
W	0.115	0.135		0.121	0.121	0.120	0.119		
X	0.308	0.313		0.316	0.310	0.309	0.309		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.371	0.367	0.366	0.369		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	0.631	0.627	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.253	0.255	0.247	0.245		
AE	1.500	1.520		1.512	1.511	1.508	1.514		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.253	0.255	0.250	0.248		
AI	2.000	2.020		2.002	2.001	2.003	2.005		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	ML
Date:	06/09/17






Audited by:	MS
Date:	06/09/22

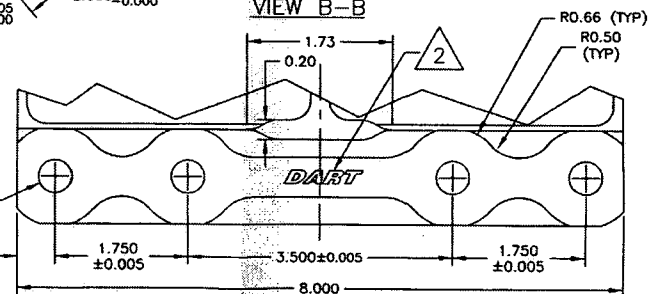
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	


05.12.06



MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C) |



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5	
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN	DRAWN BY	 DART AEROSPACE LTD. HAINESBURY, ONTARIO, CANADA	
DS	PH		
CHECKED	APPROVED	DRAWING NO. D2573	REV. E SHEET 1 OF 1
DATE	05.07.13	TITLE OUTER AFT SADDLE	SCALE 2:3

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27994